

Work Order ID 73300

Wednesday, August 31, 2011 10:45:51 AM

Page 1

Item ID: D4011-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Clamp, Short

Start Date: 9/1/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-09-11

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4011

B

100

0.00



PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

11-9-12

34

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-9-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73300

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Page 2

Item ID: D4011-5

Accept

Revision ID:

Item Name: Clamp, Short

Start Date: 9/1/2011 Start Qty: 20.00

Required Date: 9/15/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Su 9/12

counts
(30)

130



Brake NC

Brake NC

Form as per dwg
NC BRAKE

Memo

0.00

0.00

So 11/6/03

(30)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Su 10/03

counts
(30)

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 10:45:48 AM

Page 1

Work Order ID: 73300

Parent Item: D4011-5

Parent Item Name: Clamp, Short



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: revB as per dwg 09.11.18 DD verified by:JLM IPP
Rev:B 11.05.19 MADE IN HOUSE DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S14GA

Purchased

No

100

sf

48.7000

0.053

1.115789

1.6



131-9-12

304SS sheet .080

Location

Loc Qty

Loc Code

MAT020

48.7

113295

16.7

117933

32

113295

30

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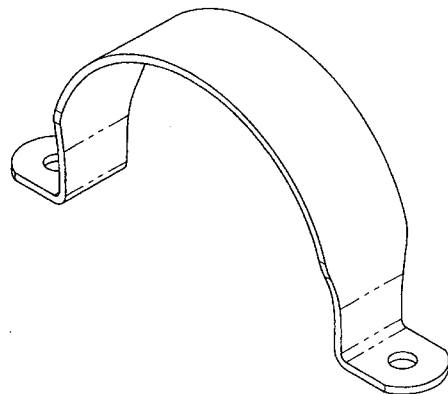
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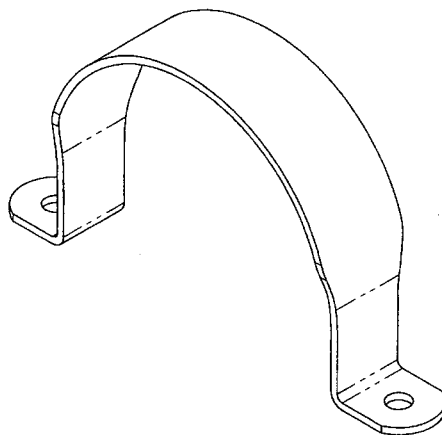
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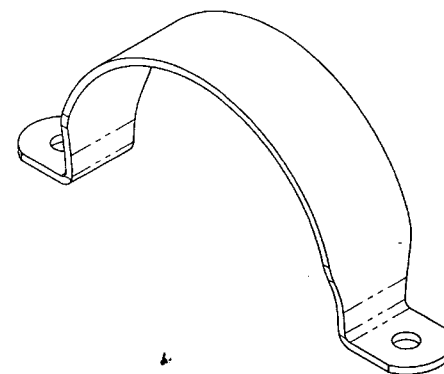
NOTE: Date & initial all entries



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

RELEASED
2009-11-24
MP

73300

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

B	SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125; ADDED -.5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4011** REV. B
TITLE **CLAMP** SCALE NTS
SHEET 1 OF 4

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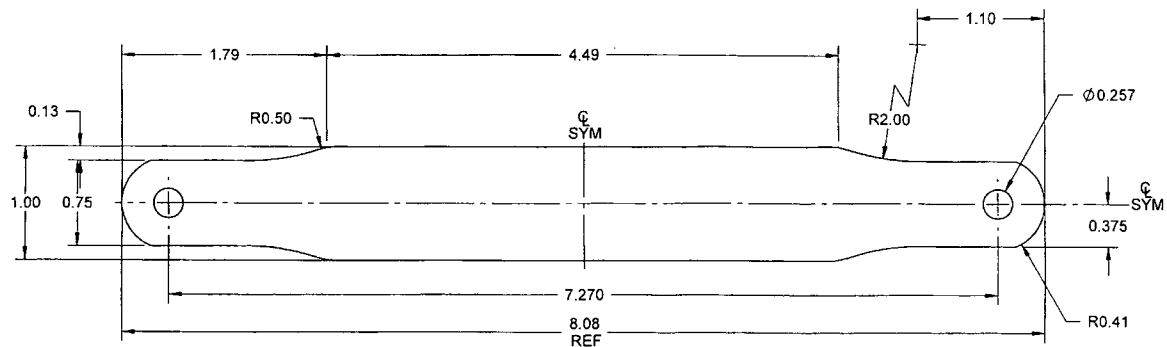
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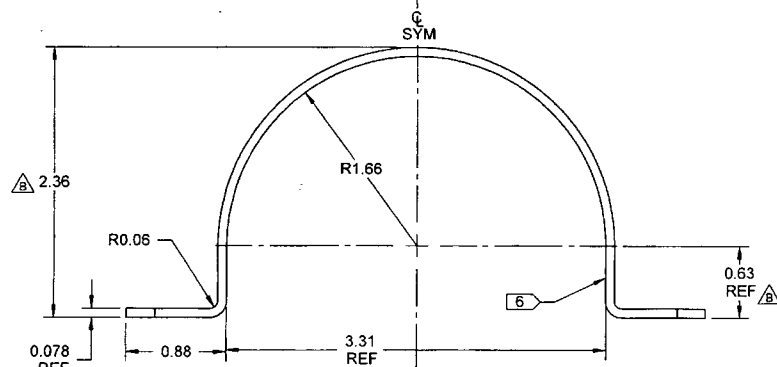
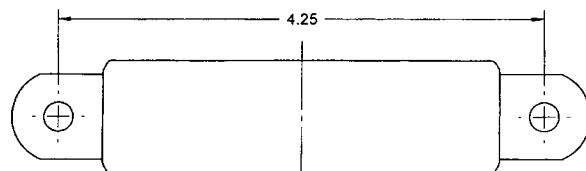
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4011-1F CLAMP, SHORT FLAT PATTERN



**D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)**

73300

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2009-11-24
MP

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	1	D4011	SHEET 2 OF 4
APPROVED	1	TITLE	SCALE
DE APPR.	1	CLAMP	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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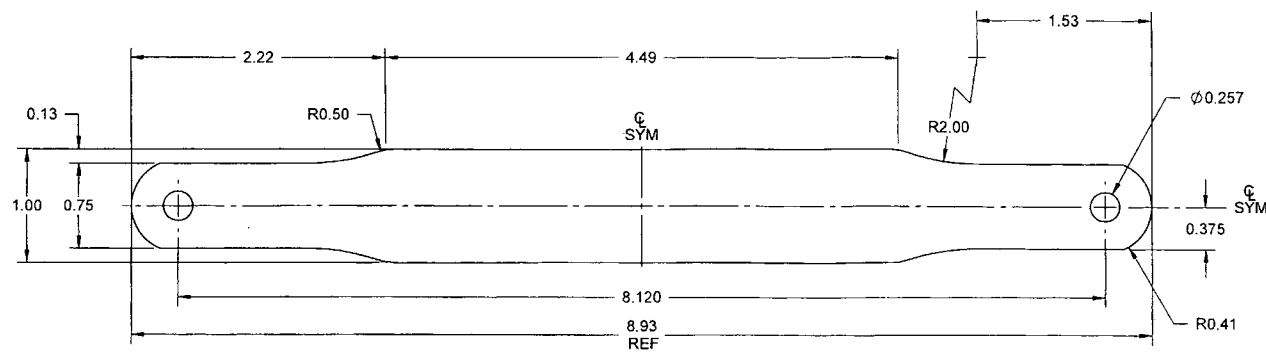
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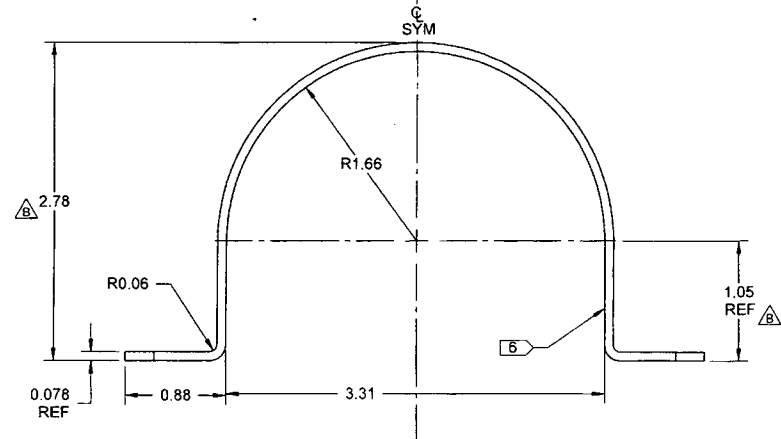
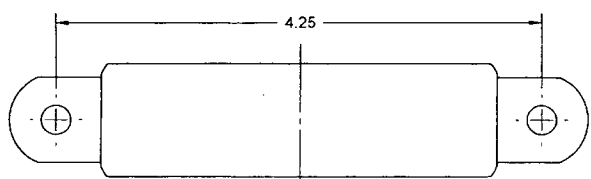
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4011-3F CLAMP FLAT PATTERN, LONG



D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

73305

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2009-11-24
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8 7 6 5 4 3 2 1

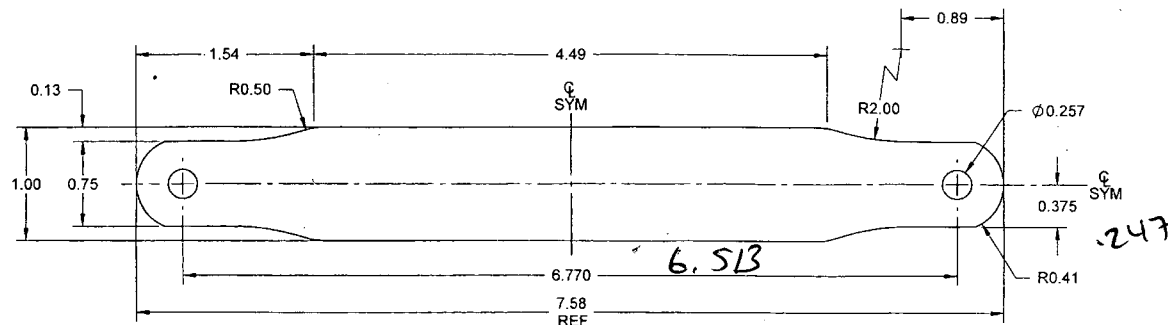
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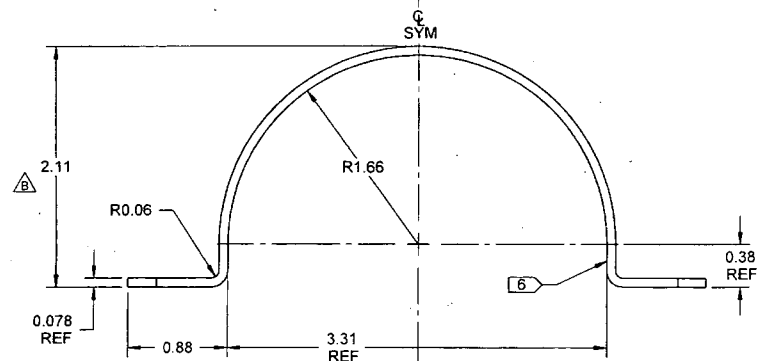
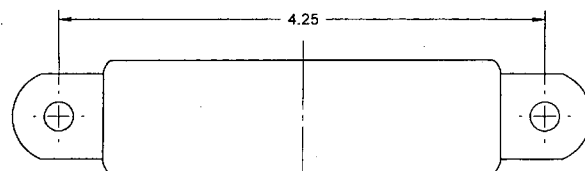
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D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

7330°

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2009-11-24
MP

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